

Work Order ID 84650

Thursday, May 17, 2012 2:17:34 PM

84650*Ship today* Page 1

Item ID: DSI 9608-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: High Skid to Low Skid Step Modification

Stop ***NS2***

Start Date: 5/17/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/17/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

mk

Date:

12-05-17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9608

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9608-011 CHG001

*8/7/17**12/05/17*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

sf

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

*8/7/17**(X)*

Work Order ID 84650

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Item ID: DSI 9608-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: High Skid to Low Skid Step Modification
 Start Date: 5/17/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/17/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9608-011								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

60 12/5/17

mw 12/05/17
mf
12-05-17

Picklist Print

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Work Order ID: 84650

Parent Item: DSI 9608-011

Parent Item Name: High Skid to Low Skid Step Modification

Start Date: 5/17/2012

Required Date: 5/17/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.05.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<i>5</i> D2643-1 Lo Skid Step Assy LH		Manufactured	No			110	Each	30.0000	0	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		30							
				16928		30							
<i>5</i> D2643-2 Lo Skid Step Assy RH		Manufactured	No			110	Each	30.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		30							
				16929		10							
				9725		20							
<i>5</i> MS20600-AD4W2 Rivet		Purchased	No			110	Each	273.0000	4	24			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST321		273							
				116391		5							
				116471		4							
				116805		4							
				117601		1							
				117885		10							
				119638		3							
				120142		146							
				121011		100							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84650

Parent Item: DSI 9608-011

Parent Item Name: High Skid to Low Skid Step Modification

Start Date: 5/17/2012

Required Date: 5/17/2012

Start Qty: 6.00

Required Qty: 6.00

MS20600-AD4W3

Purchased

No

110

Each

904.0000

12

72

Cherry Rivets

Location

Loc Qty

Loc Code

ST321

771

111636

36

117601

3

118626

474

120308

258

WA018

133

107939

133

118626

Sc

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS ~~REFERENCE ONLY~~
D350-591 REV. G OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3 OR
EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

1.0 PURPOSE

The DSI 9608-011 Step Modification Kit has been made available for operators who would like to convert a D350-591-113 High Skid Step Assembly into a Low Skid Step Assembly.

2.0 INSTALLATION

- 2.1 Remove qty 16 rivets fastening Step Leg Assembly D2582 to Step D2244. See Figure 1.
- 2.2 On left side of forward end of Step, install Step Leg Assembly D2643-1 using qty 6 MS20600AD4W3 rivets. See Figure 2.
- 2.3 On right side of forward end of Step, install Step Leg Assembly D2643-2 using qty 6 MS20600AD4W3 rivets. See Figure 2.
- 2.4 Plug un-used rivet holes in Step using MS20600AD4W2 rivets.
- 2.5 Touch up paint finish as required with chemical film material (Alodine 1200 or 1201) per MIL-C-5541, one coat of MIL-P-85582 or MIL-P-23377 primer, and 2-3 coats of MIL-C-85285 polyurethane coating to match original finish. Clean off any flaking anti-skid and touch up with Black Anti-Skid paint per MIL-W-5044 Type 2.

3.0 WEIGHT AND BALANCE

With the DSI 9608-011 Kit installed, the weight and balance is as per the D350-591-115 Low Skid Step Assembly. Refer to IIN-D350-591 Section 4.




4.0 PARTS LIST

QTY -011	P/N	DESCRIPTION
X	DSI 9608-011	HIGH SKID TO LOW SKID STEP MODIFICATION KIT
1	D2643-1	STEP LEG ASSEMBLY
1	D2643-2	STEP LEG ASSEMBLY
12	MS20600AD4W3	RIVET
4	MS20600AD4W2	RIVET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 12.04.20
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RP	12.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9608	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HIGH SKID TO LOW SKID STEP MODIFICATION KIT	NTS
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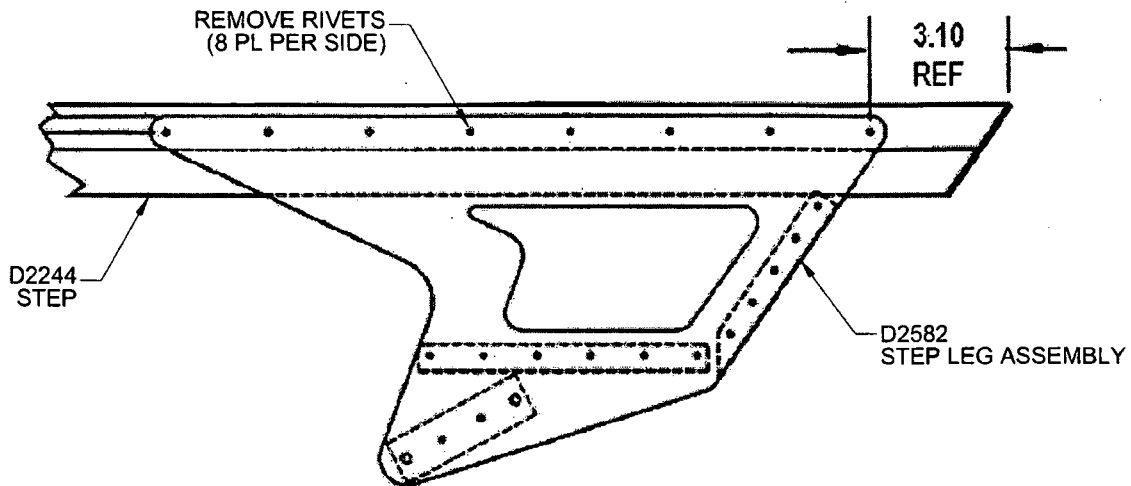


FIGURE 1
(EXISTING D350-591-113 CONFIGURATION)

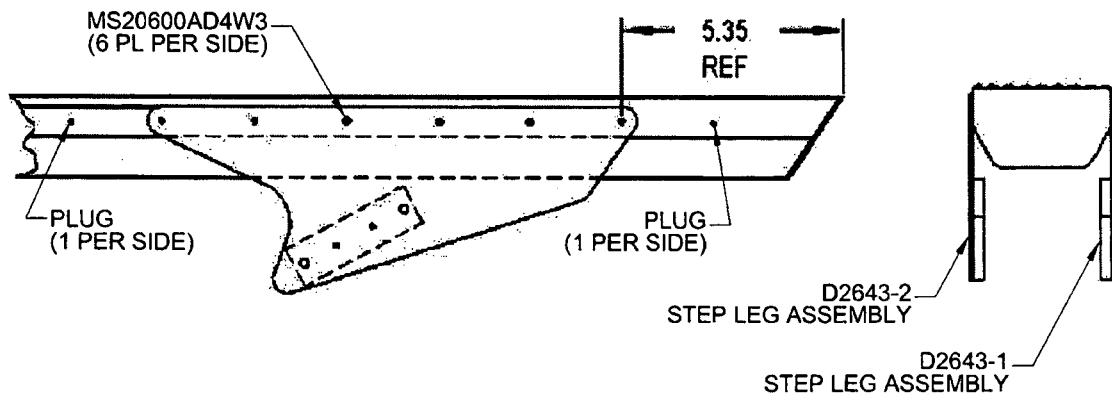


FIGURE 2
(MODIFIED CONFIGURATION)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q.P.</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9608	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HIGH SKID TO LOW SKID STEP MODIFICATION KIT	NTS
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